

Date: Monday, 05/03/2007 12:34:27 PM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30993
 Estimate Number : 10256
 P.O. Number : N/A
 This Issue : 05/03/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : 01/03/2007 Type : MACHINED PARTS
 Previous Run : 30545
 Drawing Name : MOUNTING LUG
 Part Number : D22303
 Drawing Number : D2230 REV F
 Project Number : N/A
 Drawing Revision : F
 Material : N/A
 Due Date : 03/12/2007
 Qty: 30 Um: Each
 Written By : u
 Checked & Approved By : u
 Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 71.7150 f(s)
 Lug Extrusion
 D2423
 Batch: 30062

2.0 BAND SAW BAND SAW



Comment: Band Saw
 Cut D2423 extrusion to 0.82"
 Batch: u

3.0 PG PURCHASING



Comment: PURCHASING
 Issue P/O BLKT00001
 Possible Supplier : Metec
 Machine per Drwg D2230 Rev. F

C207103108

1000 30

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect for transit damage

EP 04/06/12 (30)

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Drawing Name: MOUNTING LUG

Job Number: 30993

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



07-06-13 (30) counted



Comment: INSPECT WORK TO CURRENT STEP

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

NIA

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W

07-06-13

(30)

8.0

QC5

INSPECT WORK TO CURRENT STEP



07-06-13



Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

m 104 144

BR/mh 07-06-14

(30)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/6/14 sd



Comment: INSPECT POWDER COATINSPECT POWDER COAT

W 07-06-15 12

PTO

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/6/14 7/4/15 (12) SD 18

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.06.15

Job Completion



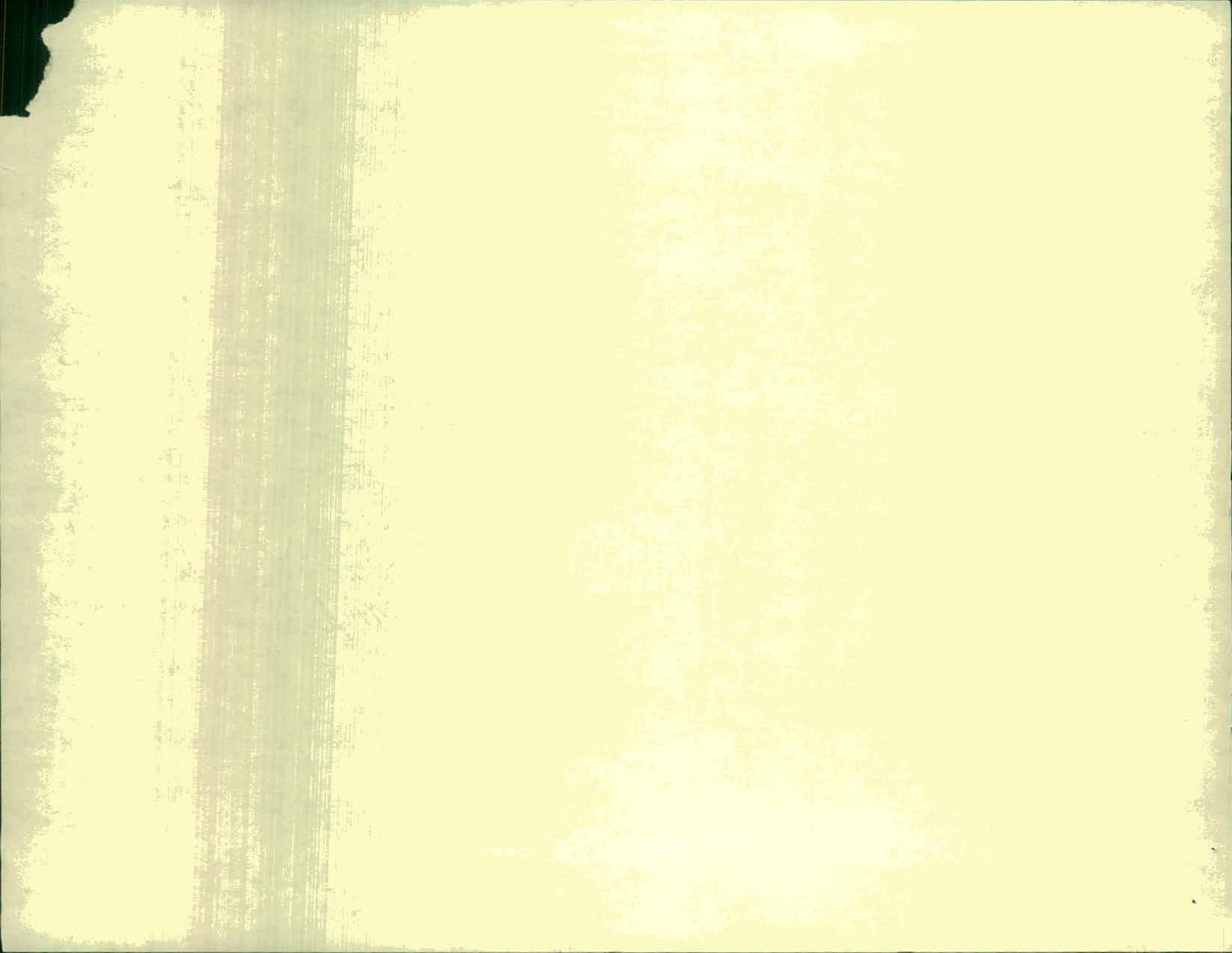
W 07-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2230-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/15	9	too much paint (irising) leaving dimples in 12 parts <i>new employee</i>	<i>QS/04/2</i>	- sand light ly to remove dimples - re alodine - re powder coat	<i>07/06/15</i> <i>M.K.</i>	<i>07/06/15</i> <i>u</i>	<i>07/06/15</i> <i>QS/04/2</i>	<i>07/06/15</i> <i>QS/04/2</i>

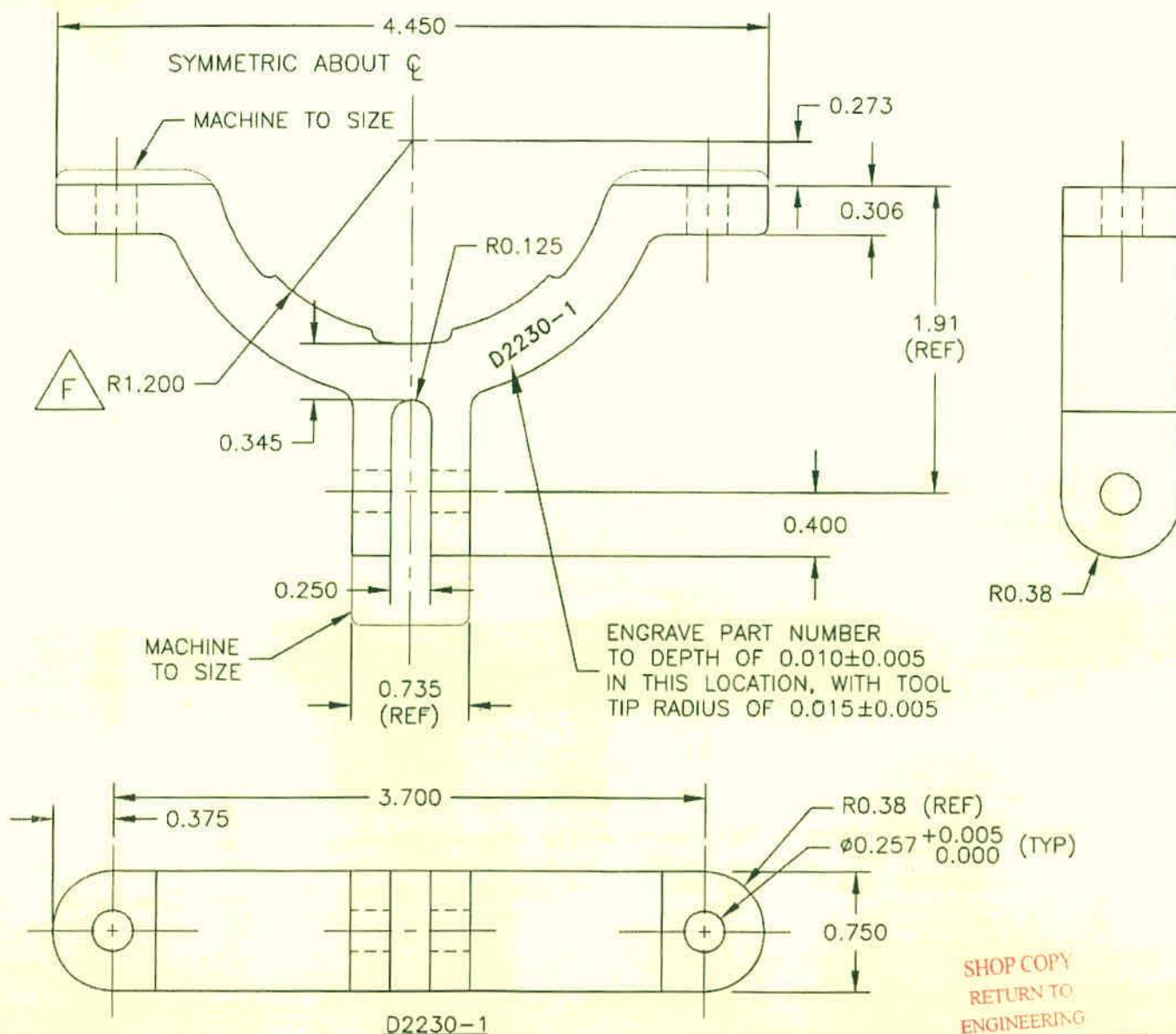
NOTE: Date & initial all entries





DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2230	SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30993

Map

July 1, 1880

Wm. L. G. 1880

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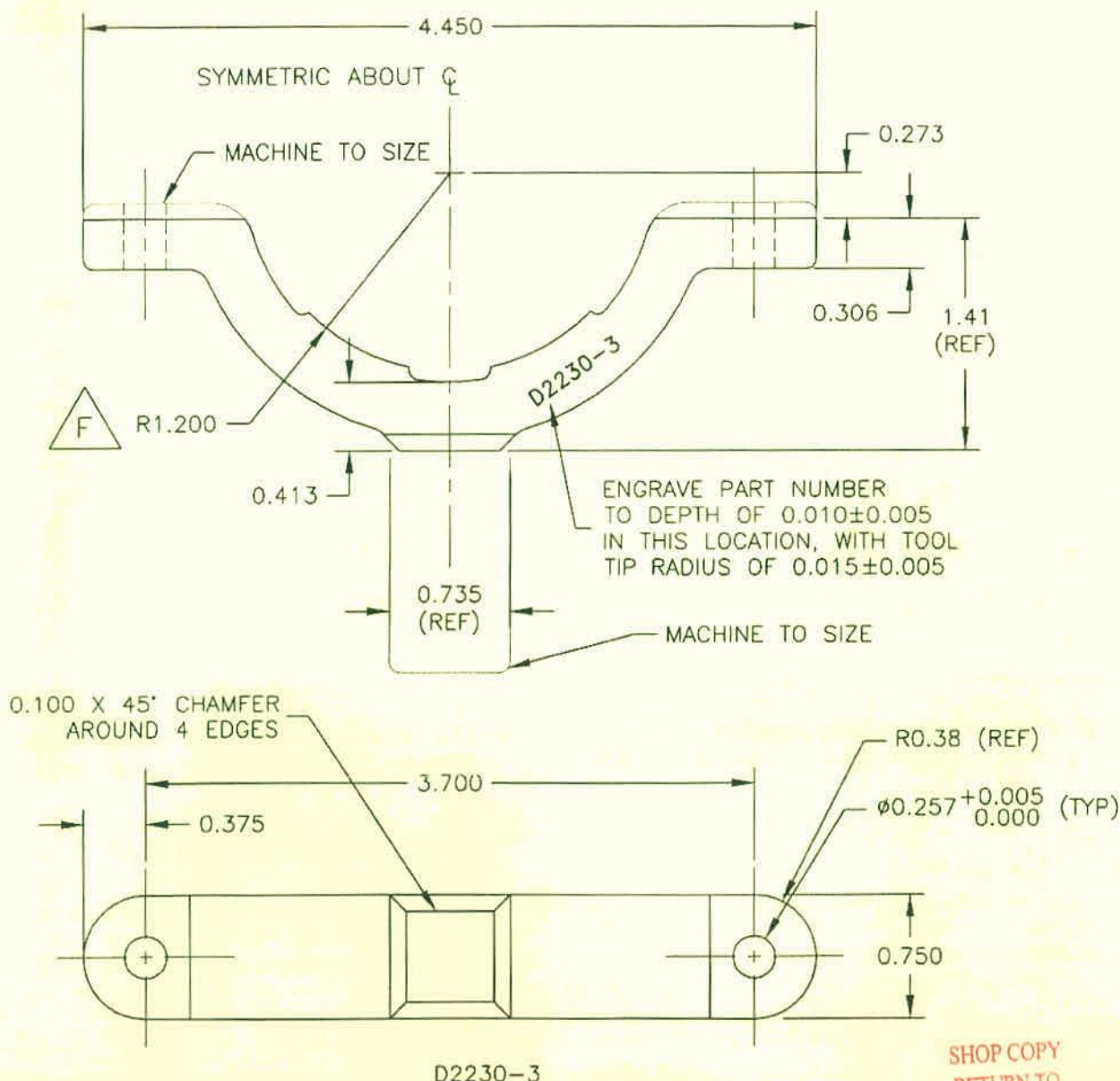
Wm. L. G. 1880

Wm. L. G. 1880



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30 ✓	D2230-3	Lug B30993 ✓	BLKT00001 ✓
50	D2731-3	Lug B30994	BLKT00001
50	D2731-7	Lug B30995	BLKT00001
150	D3235-1	Lug B30996	BLKT00001
50	D3394-1	Lug B30997	BLKT00001
50	D3394-3	Lug B30998	BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, June 12, 2007

